

# Work Order ID 70413

Tuesday, June 07, 2011 1:39:36 PM



Page 1

Item ID: D4038-1

Accept



Setup Start



Revision ID:

Item Name: Angle, Fwd, LH

Stop



Start Date: 6/7/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 11/06/07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4038	E								

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank 7.125" long

11/06/09

3

P10 →

110

0.00



HAAS 1

~~Memo~~

0.00

HAAS CNC vertical machine #1

Mill as per Dwg & Folio FA880

Dwg Rev: \_\_\_\_\_

Folio Rev: \_\_\_\_\_

Deburr

issue P10:14260

Dan's precision machines as per dwg.  
D 4038 REV. E

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4038-1 PAR #: \_\_\_\_\_ Fault Category: Machining (Fuss) NCR: (Yes) No DQA: A Date: 11.07.12  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 11/07/12

NCR: <u>70413</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/7/12</u>	<u>#100</u>	Supplier Found that qty x1 Blank was cut too short here @ Dart. R.C. employee cutting not. wasn't measuring what they were cutting. <u>LOA</u> !	<u>MP</u> <u>11/07/07</u>	→ SCRAP + Destroy qty x1 part.	<u>EL</u> <u>11-7-7.</u>	<u>S</u> <u>11/07/07</u>	<u>MP</u> <u>11/07/07</u>	<u>S</u> <u>11/07/07</u>

NOTE: Date & initial all entries

# Work Order ID 70413

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Item ID: D4038-1

Accept



Setup Start



Revision ID:

Item Name: Angle, Fwd, LH

Stop



Start Date: 6/7/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp



QC  
Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

*rec'd + inspect for transit damage  
attached CofC to W/O*

*6/4/11 (2)*



QC  
Quality Control

QC2 Inspect parts - second check

0.00

Memo

0.00

*Smoloz*

*(42)*



HandFinish  
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

*2*

*BL 11-7-7.*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 70413**

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Page 3

Item ID: D4038-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle, Fwd, LH

Start Date: 6/7/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*2X J M 6/7/07*

160

Identify as per dwg & Stock Location: *6.4*

0.00



Packaging

Memo

0.00

Packaging

*w/o 7/1/22**ES 11/07/07 (2)*

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/7/11**mr 11-07-08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 07, 2011 1:39:33 PM

Page 1

Work Order ID: 70413

Parent Item: D4038-1

Parent Item Name: Angle, Fwd, LH



Start Date: 6/7/2011

Required Date: 6/21/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A4.000W.250		Purchased	No			100	f	15.5745	0.6	6.315789			

6061T6 ANGLE 4.00 x 4.00 x .250

Location	Loc Qty	Loc Code
MAT006	14.29	
	14.29	
MAT007	1.2845	
114507	1.2845	

1.94 # 11/06/09

D4038-1P

164/7/0 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

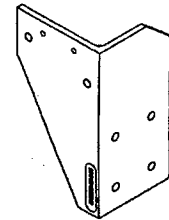
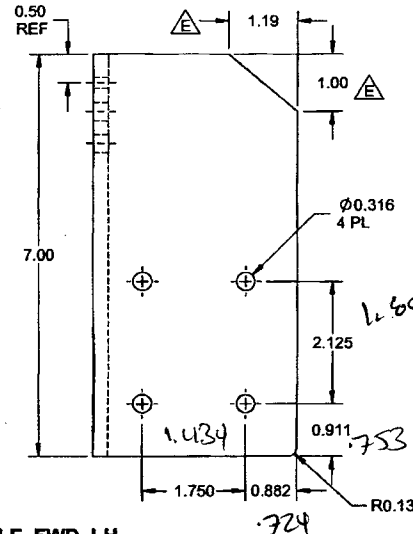
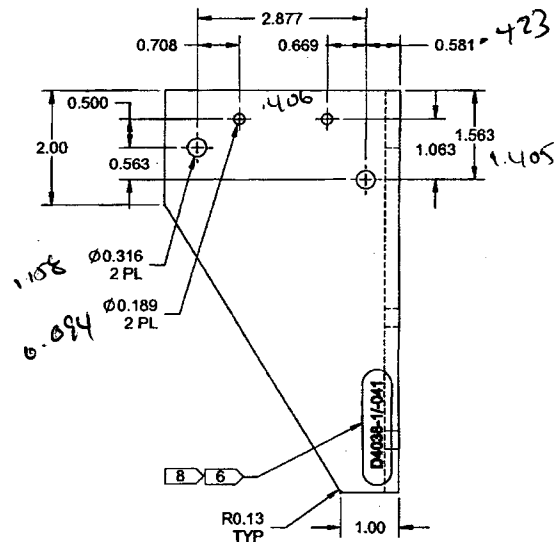
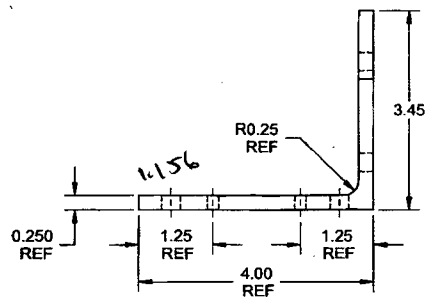
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D4038-1 ANGLE, FWD, LH**

**NOTES:**

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250  
PER AMS-QQ-A-200/8  
REF DART SPEC M6061T6A4.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (NEAR SIDE ONLY) TO MAX  
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 1.03 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4038	SHEET 3 OF 14
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.04.11	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

**RELEASED**  
2011-06-21

CD 11/06/07  
W10. 70413

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DAN'S PRECISION TOOLS INC.**

2560 Deane Road, Vars, ON K0A3H0  
Tel: (613) 835-3097 Fax: (613) 835-3760  
support@dans-precision-tools.com

**RE: CERTIFICATE OF COMPLIANCE**

**To:** DART AEROSPACE LTD.  
1270 Aberdeen Street  
Hawkesbury ON K6A-1K7  
Tel: (613) 632-5200  
Fax: (613) 632-5246

- We Certify that the part listed below meets the intent of the Purchase Order, and all applicable drawings and specifications.

**Date** : 04-Jul-11

**Purchase Order** : PO14260

**Packing Slip** : 10537

**Part Number** : D4038-1 revE

**Quantity**

(2)

*8 u107/07*

Per: \_\_\_\_\_



For Dan's Precision Tools Inc.

**DAN'S PRECISION TOOLS INC.**

Customer: DART AEROSPACE

P.O.: PO14260

W/O: \_\_\_\_\_

Part #: D4038-1 rev E

~~Bracket, Angle, FWD, LH~~ \_\_\_\_\_

Qty: X 2

1 of 1